

**Amendments to the Claims:**

This listing of claims will replace all prior versions, and listings, of claims in the application:

**Listing of Claims:**

1. (Currently Amended) A method for manufacturing a pleated filter material from a thermally bonded non-woven fabric, comprising :

forming a single fibrous web from undrawn and drawn synthetic fibers;

pre-heating the fibrous web;

calendering the single fibrous web between non-heated profiled calender rolls ~~with a cold calendar roll~~ in a single calendering step without subsequent re-heating, wherein during the single calendering step, the undrawn fibers in the single fibrous web are bonded in a tension-free manner between the non-heated profiled calender rolls to form the non-woven fabric, without inhomogeneities over the cross-section of the non-woven fabric and without the use of flat bonding, and wherein during the single calendering step, spacers are formed in the non-woven fabric to thereby form the filter material.